

**WHAT IS CLAIMED IS:**

1. A parison pinching system for attaching to first and second mold halves, each mold half having first and second cavities, the system comprising:
  - a first pinch bar for attaching to the first cavity of the first mold half, the first pinch bar of the first cavity of the first mold half having a surface and a protrusion that extends from the surface;
  - a first pinch bar for attaching to the second cavity of the first mold half, the first pinch bar of the second cavity of the first mold half having a surface and a protrusion that extends from the surface;
  - a second pinch bar for attaching to the first cavity of the second mold half, the second pinch bar of the first cavity of the second mold half having a surface and a protrusion that extends from the surface; and
  - a second pinch bar for attaching to the second cavity of the second mold half, the second pinch bar of the second cavity of the second mold half having a surface and a protrusion that extends from the surface,

wherein the protrusion of the first pinch bar of the first cavity of the first mold half and the protrusion of the second pinch bar of the first cavity of the second mold half are positioned for pinching a parison when the first and second mold halves close, and

the protrusion of the first pinch bar of the second cavity of the first mold half and the protrusion of the second pinch bar of the second cavity of the second mold half are positioned for pinching a parison when the first and second mold halves close.

2. The parison pinching system of claim 1, wherein each of the protrusions further comprises:

a first side surface;

a second side surface; and

a flat surface that intersects the first and second side surfaces.

3. The parison pinching system of claim 2, wherein each flat surface is substantially parallel to an inner mold face of each pinch bar's respective mold half.

4. The parison pinching system of claim 2, wherein each flat surface is substantially coplanar to or extends beyond an inner mold face of each pinch bar's respective mold half.

5. The parison pinching system of claim 2, wherein a cross-section of each of the protrusions is a truncated triangle.

6. The parison pinching system of claim 2, wherein the first and second side surfaces are substantially perpendicular.

7. The parison pinching system of claim 1, wherein the system is a component of a dual parison pinching system.

8. The parison pinching system of claim 1, wherein each of the first pinch bars further comprise an aperture for receiving a fastener for mounting each of the first pinch bars to the first mold half and each of the second pinch bars further comprise an aperture for receiving a fastener for mounting each of the second pinch bars to the second mold half.

9. The parison pinching system of claim 1, wherein each pinch bar adheres to the respective first and second mold halves.

10. The parison pinching system of claim 2, wherein the flat surface has a width of about 0.008-0.010 inches.

11. The parison pinching system of claim 10, wherein the flat surface has a width of about 0.009 inches.

12. An apparatus comprising:  
a mold having first and second halves;

a first pinch bar attached to the first cavity of the first mold half, the first pinch bar of the first cavity of the first mold half having a surface and a protrusion that extends from the surface;

a first pinch bar attached to the second cavity of the first mold half, the first pinch bar of the second cavity of the first mold half having a surface and a protrusion that extends from the surface;

a second pinch bar attached to the first cavity of the second mold half, the second pinch bar of the first cavity of the second mold half having a surface and a protrusion that extends from the surface; and

a second pinch bar attached to the second cavity of the second mold half, the second pinch bar of the second cavity of the second mold half having a surface and a protrusion that extends from the surface,

wherein the protrusion of the first pinch bar of the first cavity of the first mold half and the protrusion of the second pinch bar of the first cavity of the second mold half are positioned for pinching a parison when the first and second mold halves close, and

the protrusion of the first pinch bar of the second cavity of the first mold half and the protrusion of the second pinch bar of the second cavity of the second mold half are positioned for pinching a parison when the first and second mold halves close.

13. The apparatus of claim 12, wherein each of the protrusions further comprises:

a first side surface;

a second side surface; and

a flat surface that intersects the first and second side surfaces.

14. The apparatus of claim 13, wherein each flat surface is substantially parallel to an inner mold face of each pinch bar's respective mold half.

15. The apparatus of claim 13, wherein each flat surface is substantially coplanar to or extends beyond an inner mold face of each pinch bar's respective mold half.

16. The apparatus of claim 13, wherein a cross-section of each of the protrusions is a truncated triangle.

17. The apparatus of claim 13, wherein the first and second side surfaces are substantially perpendicular.

18. The apparatus of claim 12, wherein the mold is a dual-parison mold.

19. The apparatus of claim 12, wherein each of the first pinch bars further comprise an aperture for receiving a fastener for mounting each of the first pinch bar to the first mold half and each of the second pinch bars further comprise an aperture for receiving a fastener for mounting the second pinch bars to the second mold half.

20. The apparatus of claim 12, wherein each of pinch bars adhere to the respective first and second mold halves.
21. The apparatus of claim 13, wherein the flat surface has a width of about 0.008-0.010 inches.
22. The apparatus of claim 21, wherein the flat surface has a width of about 0.009 inches.
23. A method for pinching parison on a high-speed wheel machine having molds with first and second mold halves, each mold half having first and second cavities, the first cavity of the first mold half having a first pinch bar, the second cavity of the first mold half having a first pinch bar, the first cavity of the second mold half having a second pinch bar, and the second cavity of the second mold half having a second pinch bar, the method comprising the steps of:
  - extruding parison between the first cavity of the first mold half and the first cavity of the second mold half;
  - extruding parison between the second cavity of the first mold half and the second cavity of the second mold half; and
  - pinching the parison between protrusions extending from each pinch bar by moving the mold halves toward each other, such that the parison is pinched between a flat surface on each protrusion.
24. The method according to 23, wherein each of the flat surfaces is connected

to the respective pinch bar by a first and a second side surface.

25. The method according to claim 23, wherein the molds have more than one cavity.